

SECTION 4

> TASK: TRANSFER ON FROM L₁

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- WHY IS THE OPERATION NECESSARY?

TO ADD L₂ WHEN THEIR DENITRATED LIQUOR
SUPPLY IS INSUFFICIENT TO KEEP MACHINE ROOM
RUNNING, AND L₁ HAS AN EXCESS AMOUNT.

- WHEN IS THE OPERATION NECESSARY?

WHEN EVER L₂ IS IN SHORT SUPPLY AND
IS IN NEED OF LIQUOR.

NOTE: SAME APPLIES TO ALL 3 LINES

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- SAFETY:

- 1- USE CAUTION WHEN WORKING ON WET SURFACES
- 2- FOLLOW GENERAL RULES FOR STOCK PREP
- 3- WEAR LEATHER GLOVES AND SAFETY GLASSES
WHEN TURNING VALVES & BREAKING VICTAULIC CLAMPS
- 4- USE EXTRA CAUTION IF VICTAULIC CLAMP ON
CLOSED LINE (VALVE AT EACH END, ONCE TRAPPED, BOTH
VALVES CLOSED) HAS TO BE BROKEN. PRESSURE IS ON
LINE AND COULD CAUSE INJURY. BLEED OFF PRESSURE
SLOWLY, IF NOT POSSIBLE TO BLEED OFF, *USE A
VICTAULIC CLAMP PULLER WHICH WILL ALLOW YOU
STAND 5 OR 6 FEET AWAY AND LESSEN YOUR CHANCES
FOR INJURY.

- KEY ITEMS:

- 1- MINIMIZE AMOUNT OF LIQUOR TO SEWER
- 2- NOTIFY WASTE TREATMENT IMMEDIATELY OF
ANY SPILLS.
- 3- ALWAYS H₂O FLUSH TRANSFER LINE, NOSES,
TOILE BINS AND LET THEM DRAIN.
- 4- AFTER FLUSHING, LEAVE DRAIN OPEN
TO PREVENT ANY PRESSURE BUILD UP

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NOTE: L₁ → L₂

1. PLACE AUTOMATIC SWITCH FOR VALVE ON DISCHARGE SIDE OF TRANSFER PUMP 21-125 & 21-128 IN THE #2 POSITION. THIS PUTS AUTOMATIC VALVE IN POSITION TO SEND TO L₂
2. OPEN MANUAL VALVE ON TRANSFER LINE, CLOSE MANUAL VALVE TO DN TANK 2 OR 3, CLOSE DRAIN LINE.
3. NOTIFY #2 OPERATOR L₂ OF IMPENDING TRANSFER
 - a) L₂ #2 OPERATOR SHOULD HAVE HOSE HOOKED TO TRANSFER LINE AND SECURED AT TANK ONCE L₂ IS TO BE RECEIVED.
4. L₁ - #2 OPERATOR MANUALLY VALVES IN TANK TO BE SENT TO L₂ TO TRANSFER PUMP 21-125, 21-128
5. ON CONTROL PANEL IN L₁ CONTROL CONTROL, DEPRESS START BUTTON FOR PUMP 21-128, AFTER NOTIFYING L₂ - #2 THAT LIQUOR IS BEING SENT, OR IN FIELD, PUMP 21-128 CAN RUN IN HAND.
6. WHEN SUFFICIENT QUANTITY HAS BE SENT, DEPRESS STOP BUTTON ON TRANSFER PUMP 21-128

NOTE: L₂ - #2 CAN THEN SECURE CAP ON END OF HOSE WITH VICTAULIC CLAMP

L₁ - #2 POSITIONS SWITCH FOR AUTOMATIC VALVE ON DISCHARGE SIDE OF PUMP 21-128 TO # 1, THIS BLOCKS TRANSFER LINE AND DIRECTS FLOW OF DNGZ FROM DN TANK TO MIX TANK.

7. L₁ - #1 OPENS DRAIN VALVE ON LINE 1

8. NOTIFY L₂ - #2 TO OPEN H₂O VALVE ON TRANSFER

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9- FLUSH APPROXIMATELY 5¹⁰ MINUTES OR UNTIL
FLOW OF LIQUID BECOMES CLEAR.

10- L₂ - #2 CLOSE H₂O VALVE

L₂ → L₁

- 1- L₂ → #2 ATTACH ONE END OF HOSE TO DN TRANSFER
Pump #3 51-476 USING VICTAULIC CLAMP (3")
- 2- ATTACH OTHER END OF HOSE TO TRANSFER LINE
USING VICTAULIC CLAMP (2")
- 3- L₁ → #2, KEEP AUTOMATIC VALVE ON DISCHARGE
SIDE OF TRANSFER PUMP 21-128 IN THE #1 POSITION
- 4- CLOSE DRIN VALVE ON TRANSFER LINE (L₁)
- 5- OPEN VALVE ON LINE MARKED TO/FROM L₂
- 6- OPEN VALVE TO DN TANK 2 OR 3 (FLOOR LEVEL)
OPEN VALVE TO TANK 2 OR 3 AT PLATFORM
- 7- L₁ → #2 NOTIFIES L₂ → #2 HE IS READY TO
RECEIVE
- 8- L₂ → #2 MANUALLY VALVES IN TANK TO BE SENT
AND ISOLATES ALL OTHERS
- 9- PLACE H-O-A SWITCH FOR pump #3 51-476
IN AUTOMATIC
- 10- DEPRESS START BUTTON FOR Pump #3 51-476
LOCATED IN CONTROL ROOM PANEL (L₂)

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- 11- WHEN SUFFICIENT QUANTITY HAS BEEN SENT, L2-#2 DEPRESS STOP BUTTON.
- 12- L2-#2 GOES TO AN TANK
PLACE H₂O A SWITCH FOR PUMP 51-476 in "OFF"
OPEN DRAIN ON PUMP
CLOSE MANUAL VALVE ON LINE FROM TANK TO PUMP 51-476
- 14 L1-#2 OPENS DRAIN VALVE ON TRANSFER LINE (L1)
CLOSE VALVE TO TANK 2 OR 3 (L1); AT FLOOR LEVEL
LEAVE MANUAL VALVE ON TRANSFER LINE OPEN
- 15- L1-#2 NOTIFIES L2-#2 HE IS READY TO FLUSH
- 16- L2-#2 OPENS H₂O VALVE (L2) AND FLUSHES 15 MINUTES OR UNTIL LIQUID BECOMES CLEAR ON L1 SIDE
- 17- CLOSE H₂O VALVE

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USING TOTE Bin

From Line 3 To L₁ or L₂

- 1- WITH A Fork LIFT, PLACE tote Bin in position
- 2- SECURE HOSE into hole on top of Bin
- 3- CLOSE MANUAL VALVE TO SIZE PREP TANK
- 4- CLOSE MANUAL VALVE TO ON TANKS
- 5- OPEN manual VALVE to RUBBER HOSE
Approximately $\frac{1}{2}$ open
- 6- ENSURE Drain VALVE IS CLOSED, ON TOTE BIN
- 7- Start pump 81-375
- 8- WHEN TOTE Bin IS FULL
- 9- Stop pump 81-375
- 10- REMOVE HOSE FROM Bin
- 11- SECURE LID on TOP of Bin
- 12- POSITION MANUAL VALVES TO DIRECT FLOW
FROM MIX TANK TO SIZE PREP.
- 13- TRANSFER tote bin to L₁ or L₂ USING Fork LIFT

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on LI

- 1- PLACE TOTE BIN NEAR OFF LINE TRANSFER PUMP
21-125/21-128
- 2- ATTACH ONE END OF HOSE TO DRAIN VALVE ON
TOTE BIN USING VICTAULIC CLAMP.
- 3- ATTACH OTHER END TO INLET OF PUMP 21-125
- 4- ATTACH ONE END OF 2ND HOSE TO DISCHARGE
SIDE OF PUMP 21-125
- 5- SECURE OTHER END OF 2ND HOSE IN TANK TO
RECEIVE LIQUOR
- 6- OPEN DRAIN VALVE (SEE DWG NO.2)
- 7- OPEN LID ON TOTE BIN (DWG NO.2)
- 8- USING SWITCH LOCATED ON WEST WALL
PUT H-O-A SWITCH FOR PUMP 21-125 IN HAND
POSITION.

NOTE: THIS IS A SPRING LOADED SWITCH AND WHEN
PUT IN HAND POSITION IT MUST BE HELD
IN THIS POSITION TO KEEP PUMP RUNNING

- 9- WHEN TOTE BIN IS EMPTY
- 10- RELEASE H-O-A SWITCH
- 12- CLOSE DRAIN VALVE ON TOTE BIN (DWG #2)

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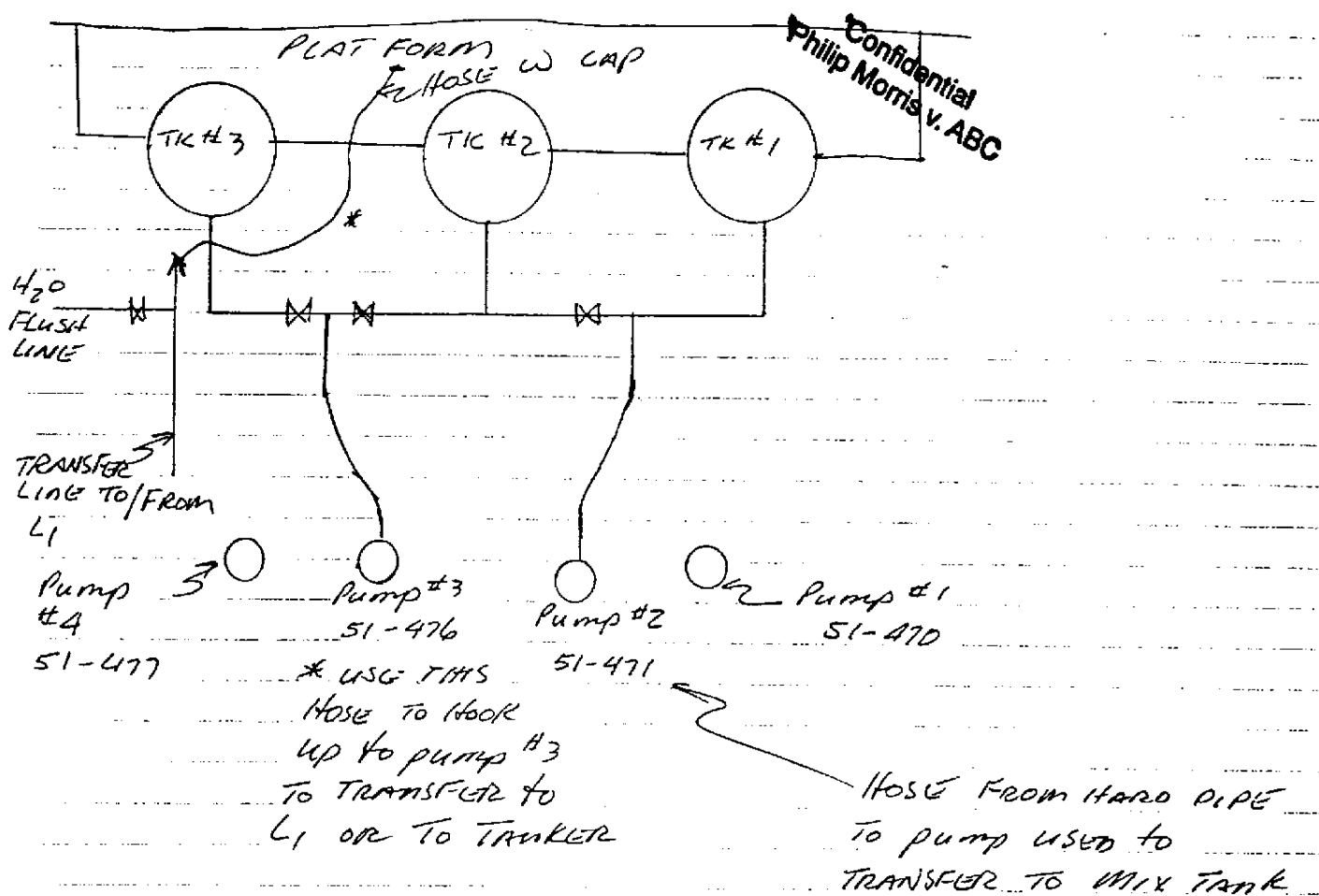
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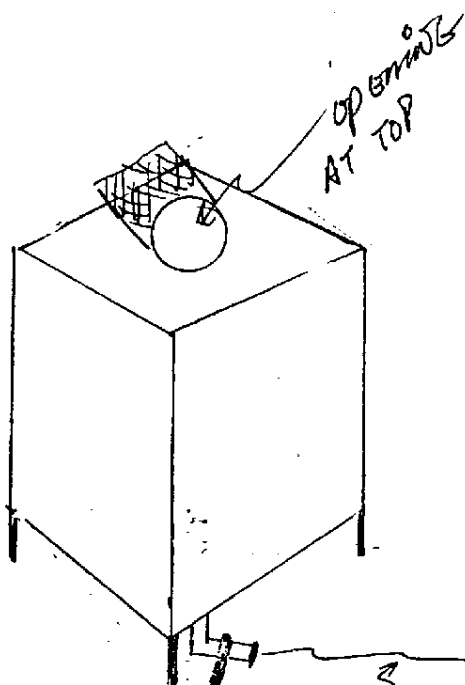
- DISCONNECT VICTAULIC CLAMPS ON HOSES
TO BIN
- .. USING PAPER MAKERS HOSE, INSERT INTO HOSE, TURN H₂O
ON, START PUMP (OFFLINE) & RINSE HOSES (REQUIRES 2 PEOPLE)
- OPEN DRAIN ON TOTE BIN (ONLY H₂)
- RINSE TOTE FROM TOP USING H₂O HOSE
UNTIL CLEAN
- DISCONNECT HOSES FROM OFF LINE PUMP 21-125/128,
STORE HOSES IN STOCK PREP 1
HOSE ROOM 1ST FLOOR.
- CLOSE DRAIN ON TOTE BIN
- SECURE TOP OF TOTE BIN

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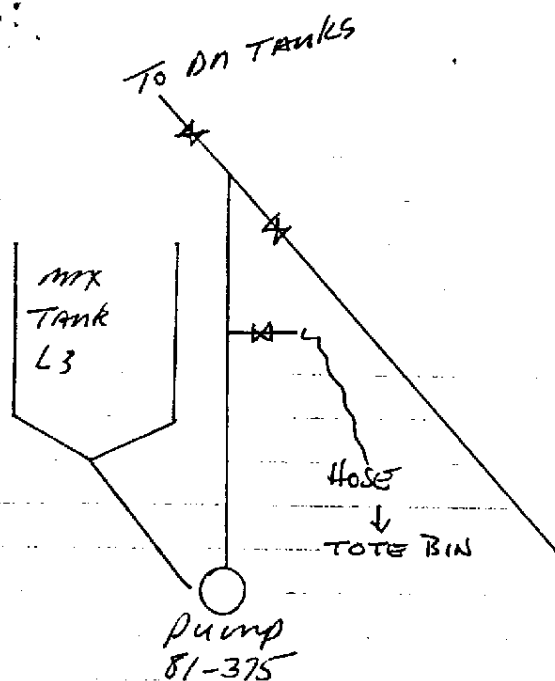
DWEN No. 2



- ① VALVE HANDLE
in THIS POSITION
VALVE is open
- ② VALVE HANDLE PARALLEL
WITH PIPE is in CLOSED POSITION

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DWG No. 3

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